

Work Order ID 61921

Page 1

Thursday, September 09, 2010 1:20:01 PM

Item ID: D412-706-011

Accept



Setup Start



Revision ID:

Item Name: Fuel Purge Canister

Stop



Start Date: 9/9/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/16/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10-9-09

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
DSI 9494	A
IIN-D412-706	A

100



DOCUMENT CONTROL

DC

Document Control

Memo

0.00

Photocopy bluefile and create labels per PPP D412-706-011 CHG003

HJ for BG 10-10-01

S. Sholos

110



Pick Kit

0.00

Packaging

Memo

0.00

Packaging

10/10/10

SL (R)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61921

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Item ID: D412-706-011

Accept



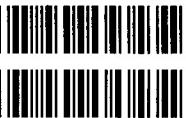
Setup Start



Revision ID:

Item Name: Fuel Purge Canister

Stop



Start Date: 9/9/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/16/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

S. 10/10/05

(+) _____

130



Packaging

Packaging

0.00

0.00

10/10/05 (1)

Packaging

Identify and pack for shipping as per PPPD412-706-011
Location: _____
PPP Rev: F

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/10/05 (2)

U 10/10/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 61921



Parent Item: D412-706-011



Parent Item Name: Fuel Purge Canister

Start Date: 9/9/2010

Required Date: 9/16/2010

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:E 04.12.03 Remove AN6289-6D; Change Qty of 924-6D□KJ/JLM
 IPP Rev:F 08-05-14 revise comment in seq.17/24 DD verified
 by:EC IPP rev G
 10.01.18 per DSI9494 EC verified by:DD IPP Rev:H 10.03.23
 as per IIN revA DD verified by:EC IPP Rev:I 10.05.10 as per
 chg003 DD verified :EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-5A 		Purchased	No			110	Each	1,517.000	4	4		10/10/458	

S Bolt

Location	Loc Qty	Loc Code
ST350	1517	
105057	517	4
115016	500	
115371	500	

S AN814-6D

Plug Purchased No

Location	Loc Qty	Loc Code
ST329	9	
114742	9	1

S AN815-6D

Union-M-Flare Purchased No

Location	Loc Qty	Loc Code
ST329	28	
114348	3	2
114523	5	
114988	20	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 61921



Parent Item: D412-706-011



Parent Item Name: Fuel Purge Canister

Start Date: 9/9/2010

Required Date: 9/16/2010

Start Qty: 1.00

Required Qty: 1.00

AN815-8D

Purchased

No

110

Each

15.0000

1

1
10/10/10 SP

Union-M-Flare

Location	Loc Qty	Loc Code
ST329	15	
113749	5	
114544	10	

AN832-6D

Purchased

No

110

Each

11.0000

1

1
10/10/10 SP

UNION

Location	Loc Qty	Loc Code
ST333	11	
114742	11	

AN833-6D

Purchased

No

110

Each

9.0000

2

1
10/10/10 SP

Elbow, Bulkhead-M-Flare

AN833-8D

Purchased

No

110

Each

16.0000

1

2
1
10/10/10 SP

ELBOW

Location	Loc Qty	Loc Code
ST333	16	
114341	7	
114544	9	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 61921



Parent Item: D412-706-011



Parent Item Name: Fuel Purge Canister

Start Date: 9/9/2010

Required Date: 9/16/2010

Start Qty: 1.00

Required Qty: 1.00

AN924-6D

Purchased

No

110

Each

20.0000

4

4

10/10/10 usf

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST335	20	
114742	10	4
114988	10	

AN924-8D

Purchased

No

110

Each

14.0000

1

1

10/10/10 usf

NUT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST335	14	
114341	6	1
114544	8	

AN938-6D

Purchased

No

110

Each

15.0000

1

1

10/10/10 usf

Tee

AN960JD10

NAS1149D0363J

Purchased

No

101925

110

Each

16.0000

8

8

10/10/10 usf
M115623 10/10/10 usf

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST	6	
107715	6	
ST335	10	
105792	10	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 61921



Parent Item: D412-706-011



Parent Item Name: Fuel Purge Canister

Start Date: 9/9/2010

Required Date: 9/16/2010

Start Qty: 1.00

Required Qty: 1.00

AN960JD10L

NAS1149D0332J



Washer

Purchased No 110 Each 2,219.000 4 4



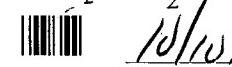
re/bk4sl

AN960JD916



WASHER

Purchased No 110 Each 8.0000 2



D2001-4



Valve Assembly (1/4")

Manufactured No 109174 110 Each 8.0000 1

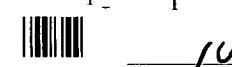


D3262-043



Canister Assembly

Manufactured No 55525 110 Each 4.0000 1



Location Loc Qty Loc Code

ST348 2219
110985 2219

Location Loc Qty Loc Code

ST348 8
109174 8

Location Loc Qty Loc Code

ST002 8
55525 2
56682 6

Location Loc Qty Loc Code

ST144 4
59738 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 61921



Parent Item: D412-706-011



Parent Item Name: Fuel Purge Canister

Start Date: 9/9/2010

Required Date: 9/16/2010

Start Qty: 1.00

Required Qty: 1.00

D3264-1

Manufactured No

110

Each

11.0000

2

2
10/10/48

Bracket

Location	Loc Qty	Loc Code
ST144	11	
<u>55733</u>	5	
<u>59451</u>	6	

D3297-1-0098

Manufactured No

110

Each

6.0000

1

1
10/10/48

HOSE ASS'Y

Location	Loc Qty	Loc Code
ST194	6	
<u>47500</u>	2	
<u>59540</u>	4	

D3297-3-0085

Manufactured No

110

Each

6.0000

1

1
10/10/48

HOSE ASS'Y

Location	Loc Qty	Loc Code
ST194	6	
<u>47501</u>	2	
<u>59543</u>	4	

D3297-3-0210

Manufactured No

110

Each

6.0000

1

1
10/10/48

HOSE ASS'Y

Location	Loc Qty	Loc Code
ST194	6	
<u>47502</u>	2	
<u>59544</u>	4	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 61921



Parent Item: D412-706-011



Parent Item Name: Fuel Purge Canister

Start Date: 9/9/2010

Required Date: 9/16/2010

Start Qty: 1.00

Required Qty: 1.00

D3298-005



Tube Assembly

Manufactured No

110

Each

15.0000

1

1

10/10/4SF

D3298-007



Tube Assembly

Manufactured No

110

Each

10.0000

1

1

10/10/4SF

D3299-3



Fitting

Manufactured No

110

Each

21.0000

1

1

10/10/4SF

D3299-5



Fitting

Manufactured No

110

Each

17.0000

1

1

10/10/4SF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 61921



Parent Item: D412-706-011



Parent Item Name: Fuel Purge Canister

Start Date: 9/9/2010

Required Date: 9/16/2010

Start Qty: 1.00

Required Qty: 1.00

D3299-7
Fitting

Manufactured No 110 Each 12.0000



10/10/45P

D3301-1
Placard

Manufactured No ST050 12
57411 12



10/10/45L

D3301-3
Placard

Manufactured No ST050 25
43658 1
56601 12
56685 12



10/10/45L

1

1

1

1

1

1

1

1

1

1

1

1

1

1

1

1

1

1

1

1

1

1

1

1

1

1

1

1

1

1

1

D3302-1
Doubler

Manufactured No ST050 15

47423

60250

9

6

Each

9.0000



10/10/45P

Location Loc Qty Loc Code

Location	Loc Qty	Loc Code
ST143	9	
39847	1	
47424	1	
54577	3	
60251	4	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 61921



Parent Item: D412-706-011



Parent Item Name: Fuel Purge Canister

Start Date: 9/9/2010

Required Date: 9/16/2010

Start Qty: 1.00

Required Qty: 1.00

D3302-3



Doubler

Manufactured No

110 Each 12.0000



1
10/10/45P

D3329-1



Bushing

Manufactured No

Location ST142
54578

Loc Qty 12
12

110 Each 10.0000



1
10/10/45D

D4054-001



Tube Assembly

Manufactured No

Location ST051
34218

Loc Qty 10
10

110 Each 12.0000



2
10/10/45P

D4054-003



Tube Assembly

Manufactured No

Location ST193
58155
58970

Loc Qty 12
8
4

110 Each 12.0000



1
10/10/45P

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 61921



Parent Item: D412-706-011



Parent Item Name: Fuel Purge Canister

Start Date: 9/9/2010

Required Date: 9/16/2010

Start Qty: 1.00

Required Qty: 1.00

D4054-009



Tube Assembly

Manufactured No

110 Each

6.0000

1

1

10/10/45

MS21042L3



Nut

Purchased No

Location

ST193

Loc Qty

6

Loc Code

58157

6

10/10/45

MS21919-WDG9



Clamp

Purchased No

Location

ST300

Loc Qty

2081

Loc Code

104625

10

114523

109

114784

1962

10/10/45

MS21920-42



CLAMP(per MIL-DTL-8783C)

Purchased No

Location

ST307

Loc Qty

43

Loc Code

111578

43

10/10/45

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Thursday, September 09, 2010 1:20:06 PM

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Work Order ID: 61921



Parent Item: D412-706-011



Parent Item Name: Fuel Purge Canister

Start Date: 9/9/2010

Required Date: 9/16/2010

Start Qty: 1.00

Required Qty: 1.00

MS29512-06



O-RING

Purchased No 110 Each 27.0000



10/10/4 SF

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST294	27	
113691	7	
114742	20	

Purchased No 110 Each 22.0000



10/10/4 SF

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST294	22	
113706	22	

Purchased No 110 Each 23.0000



10/10/4 SF

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST295	23	
109166	23	

MS35489-11



GROMMET

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-706 REV. A AND ICA-D412-706 REV. 0

REF TCCA STC: SH04-54

REF FAA STC: SR02055NY

REF. EASA STC: EASA.I.M.R.S.01180

REFERENCE UNL

S

DESCRIPTION:

AT CHG 002, THE D412-706-011 FUEL PURGE CANISTER INSTALLATION HAS BEEN MODIFIED WITH LARGER VENT LINES TO ELIMINATE BACK PRESSURE THAT MAY OCCUR WHEN STARTING THE SECOND ENGINE IF THE CANISTER HAS NOT BEEN PROPERLY DRAINED. THE BACK PRESSURE IS EVIDENCED BY AN ONGOING VAPOR DISCHARGE FROM THE CANISTER VENT AT LOW TO MEDIUM RPM WHILE STARTING THE 2nd ENGINE. THE UPDATED PARTS LIST IS SHOWN BELOW:

IS

QTY -011	PART NUMBER	DESCRIPTION
X	D412-706-011	FUEL PURGE CANISTER INSTALLATION (212/412)
1	D2001-4	VALVE ASSEMBLY
1	D3262-043	CANISTER ASSEMBLY (WAS D3262-041)
2	D3264-1	BRACKET
1	D3297-1-0098	HOSE ASSEMBLY
1	D3297-3-0085	HOSE ASSEMBLY
1	D3297-3-0210	HOSE ASSEMBLY
1	D4054-001	TUBE ASSEMBLY (WAS D3298-001)
1	D4054-003	TUBE ASSEMBLY (WAS D3298-003)
1	D3298-005	TUBE ASSEMBLY
1	D3298-007	TUBE ASSEMBLY
1	D4054-009	TUBE ASSEMBLY (WAS D3298-009)
1	D3299-7	FITTING (WAS 3299-1)
1	D3299-3	FITTING
1	D3299-5	FITTING
1	D3301-1	PLACARD
1	D3301-3	PLACARD
1	D3302-1	DOUBLER
1	D3302-3	DOUBLER
2	D3329-1	BUSHING
4	AN3-5A	BOLT
1	AN814-6D	PLUG
2	AN815-6D	UNION
1	AN815-8D	UNION (WAS AN815-6D)
1	AN832-6D	UNION
1	AN833-6D	ELBOW
1	AN833-8D	ELBOW (WAS AN833-6D)

CANADA	
DEPARTMENT OF TRANSPORT	
AIRCRAFT CERTIFICATION	
BRANCH	
DAO # 01-O-01	
APPROVED	
BY:	<i>[Signature]</i>
D. SHEPHERD (DE # 02)	
DATE:	10.01.07
CERT. NO.:	SH04-54
ISSUE NO.:	1

A	NEW ISSUE	RF	10.01.07			
REV.	DESCRIPTION			BY	DATE	
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. DSI 9494 REV. A SHEET 1 OF 3				
DRAWN	RF					
CHECKED	#					
MFG. APPR.	MA					
APPROVED	#					
DE APPR.	#					
DATE	10.01.07	SCALE	NTS			
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REFERENCE

Continue from previous sheet

4	AN924-6D	NUT
1	AN924-8D	NUT (WAS AN924-6D)
1	AN938-6D	TEE
4	AN960JD10L	WASHER (OR NAS1149D0332J)
8	AN960JD10	WASHER (OR NAS1149D0363J)
2	AN960JD916	WASHER
4	MS21042L3	NUT
2	MS21919WDG9	CLAMP
2	MS21920-42	CLAMP
8	MS29512-06	O-RING (WAS MS28778-6)
2	MS29512-08	O-RING (WAS MS28778-6)
1	MS35489-11	GROMMET

FOR CUSTOMERS WHO HAVE EXPERIENCED THIS PROBLEM IN SERVICE, THE DSI 9494-011 UPGRADE KIT IS AVAILABLE TO UPGRADE THE INSTALLATION FROM CHG 001 TO CHG 002.

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9494-011	212/412 CANISTER UPGRADE KIT
1	D3262-043	CANISTER ASSEMBLY
1	D4054-001	TUBE ASSEMBLY
1	D4054-003	TUBE ASSEMBLY
1	D4054-009	TUBE ASSEMBLY
1	D3299-7	FITTING
1	AN815-8D	UNION
1	AN833-8D	ELBOW
1	AN924-8D	NUT
2	MS29512-08	O-RING

WEIGHT AND BALANCE:
NO CHANGE

CANADA	
DEPARTMENT OF TRANSPORT	
AIRCRAFT CERTIFICATION	
BRANCH	
DAO # 01-O-01	
APPROVED BY: <i>[Signature]</i>	
D. SHEPHERD (DE # 02)	
DATE:	10.01.07
CERT. NO.:	SH04-54
ISSUE NO.:	1

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. DSI 9494 REV. A SHEET 2 OF 3
DRAWN	RF	
CHECKED	#	
MFG. APPR.	M/A	
APPROVED	#	
DE APPR.	#	
TITLE		SCALE
212/412 CANISTER UPGRADE KIT		NTS
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